



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2600-3-BENT-LH
Job Sheet 203953



Part No: D2600-3-BENT-LH

Job Qty: 5 pcs

Part Name: Extrusion Bent LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/27/19

Type: Stock

Description:

Note: DWG D2750 REV G SHEET 4, D2600 REV E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	5 pcs	12/27/19	12/27/19	0.20	1.61	Skidtubes - Bend		MLH
110	QC 5	5 pcs	12/27/19	12/27/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	5 pcs	12/27/19	12/27/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S237355



Part: D2600-3-BENT-LH

Job No: 203953

Serial No/Batch: S237355

Revision:

Inspector:

Exp Date:

Instructions:

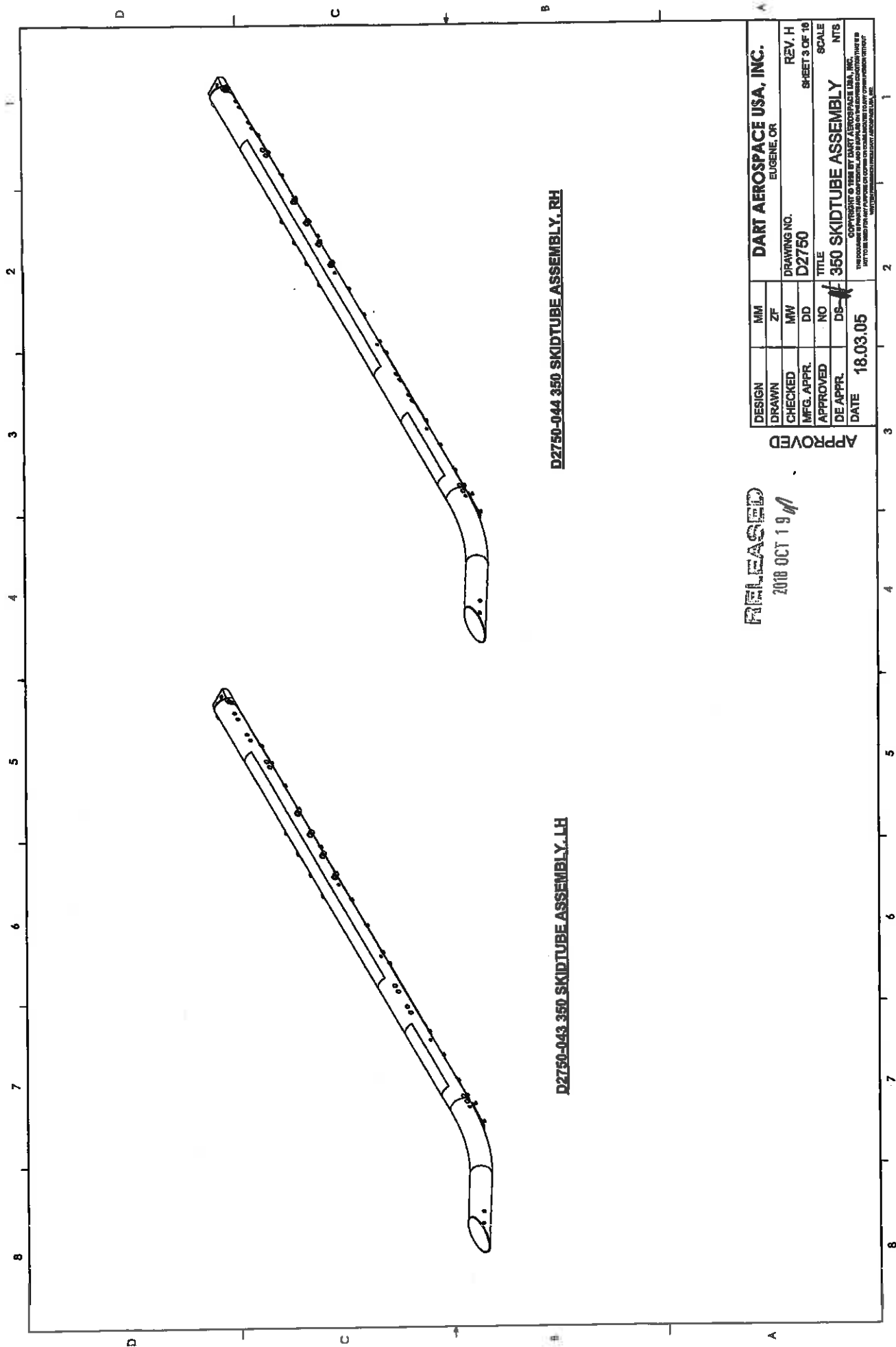
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/06/19

Plex 11/28/19 3:07 PM Dart.lajeunesse.marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - SA	5 pcs	12/27/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (CNC Delta 100 Bender) Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC Descriptions: bending machine as per program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750 4- cut aft end of tube as per dwg D2750 110 - (QC5- Inspect part completeness to step on W/O) 120 - (Identify as per dwg & Stock Location: <u>LG002</u>) LOCATION : LG002 130 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-3-130	Extrusion Round 3" 350	5 pcs (1 ea)	100-Skidtubes - Bend - 1	5124531	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - Bend - 1	D2600-3-130	5	165	0	
Part Specifications					
Specifications could not be found.					

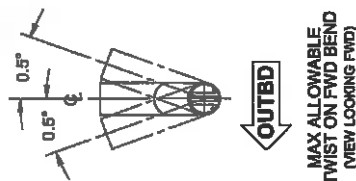
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2018 OCT 19

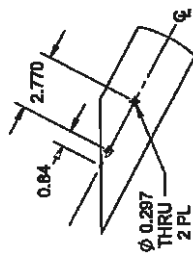
APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MM	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 3 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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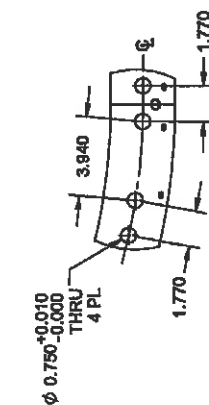


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

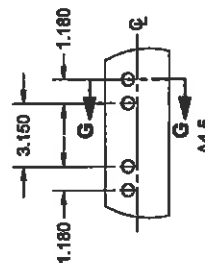
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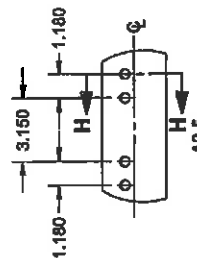
D7-5
DETAIL A
SCALE 2X



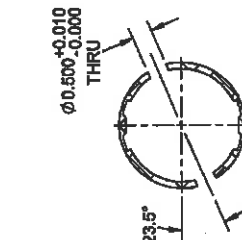
DETAIL B
SCALE 2X



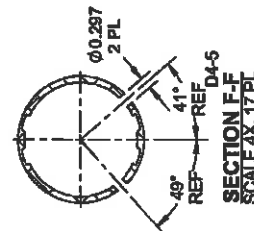
DETAIL C
SCALE 2X



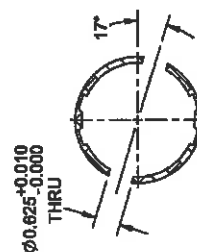
D3-5
DETAIL D
SCALE 3X



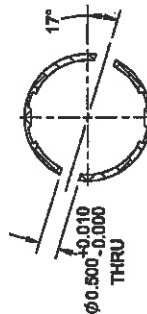
D5-5
SECTION E-E
SCALE 4X, 2 PL



REF REF D4-5
SECTION F-F
SCALE 4X, 17 PL



B4-5
SECTION G-G
SCALE 4X, 4 PL



B2-H
SECTION H-H
SCALE 4X, 4PL

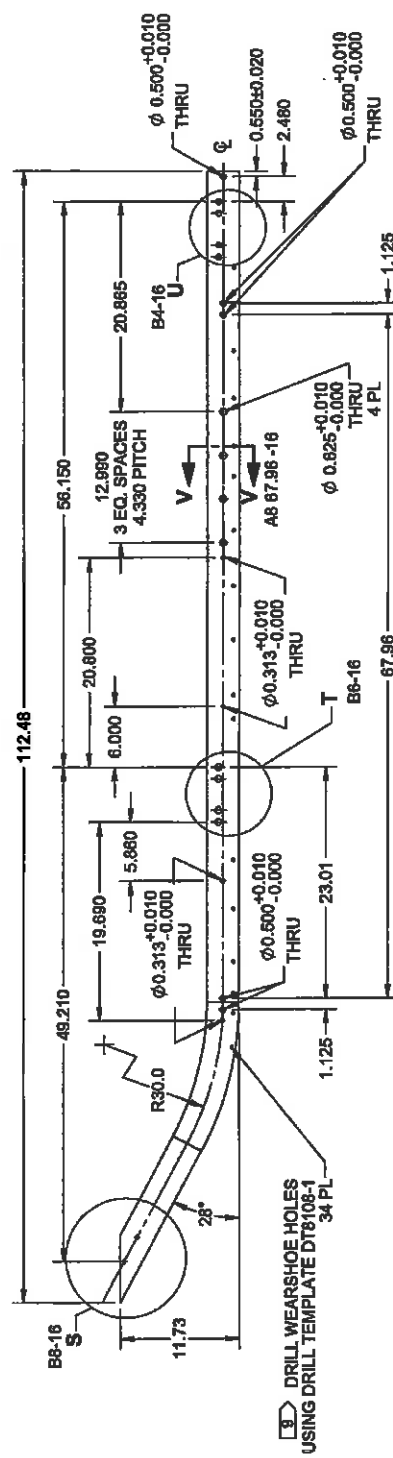
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DESIGN	MM	TITLE	360 SKIDTUBE ASSEMBLY
DRAWN	ZF	DRAWING NO.	D2750
CHECKED	MM	REV. H	REV. H
MFG. APPR.	DD	SHEET 5 OF 16	
DE APPR.	DS	SCALE	NTS

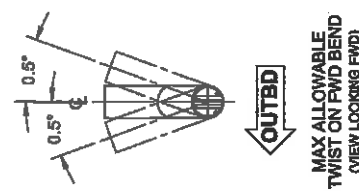
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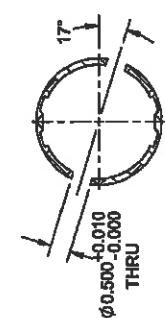
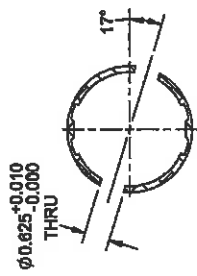
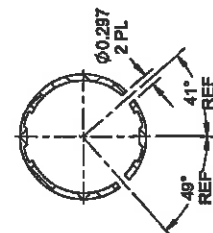
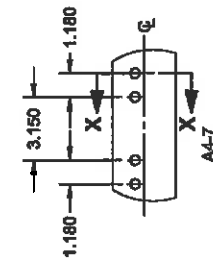
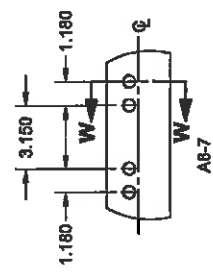
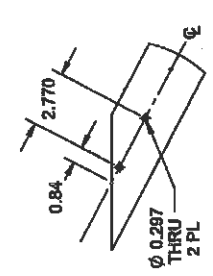
1 2 3 4 5 6 7 8



DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1



D2750-3 LH SKIDTUBE

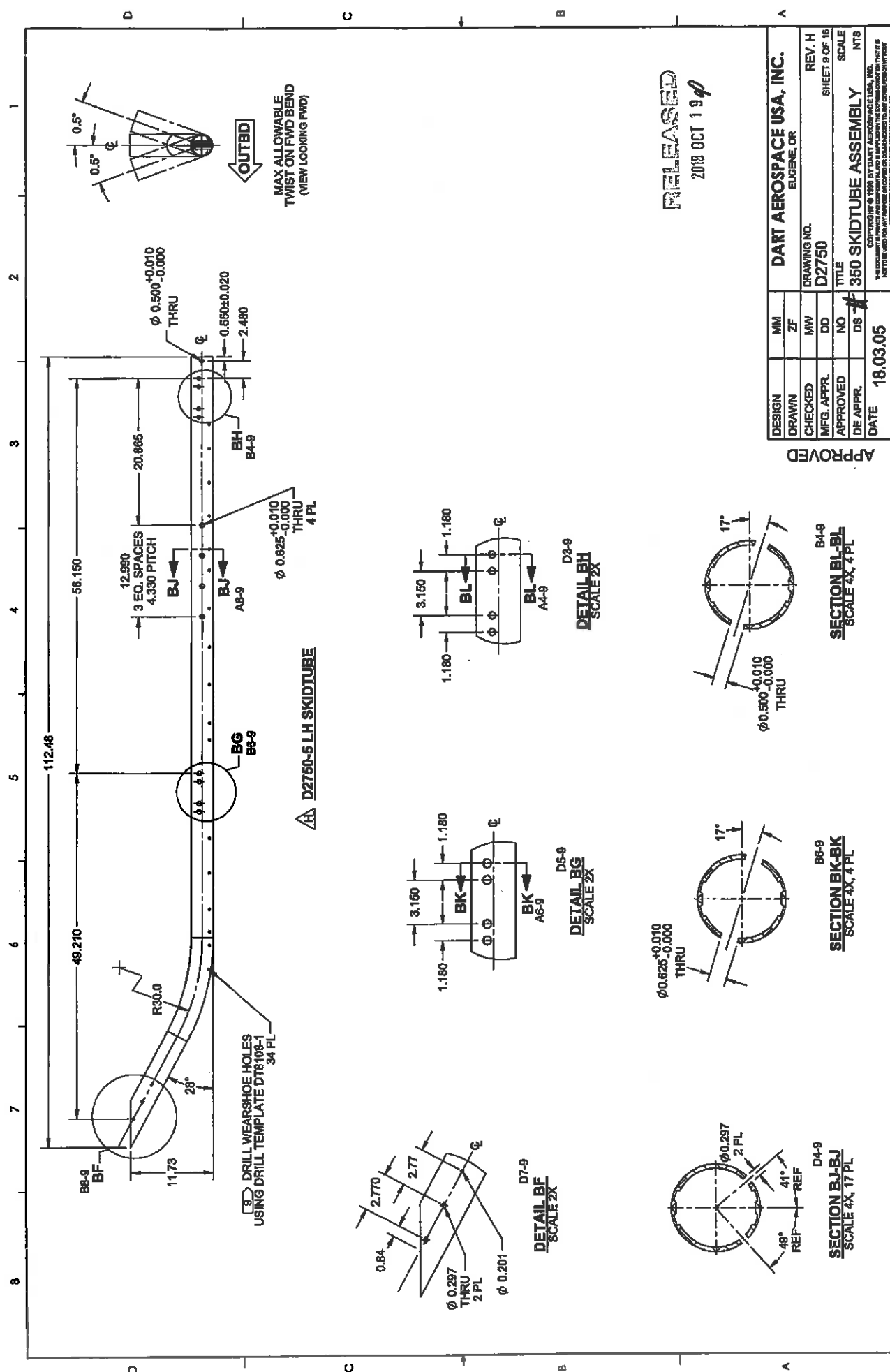


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DRAWN	ZF	EUGENE, OR
CHECKED	MW	DRAWING NO. D2750
MFG. APPR.	DD	REV. H
APPROVED	NO	SHEET 7 OF 16
DE APPR.	DS	TITLE 350 SKIDTUBE ASSEMBLY
DATE	18.03.05	SCALE NTS

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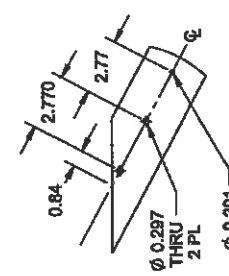


OUTBD

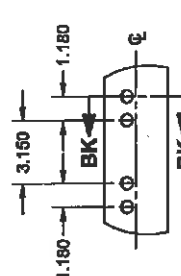
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

D2750-5 LH SKIDTUBE

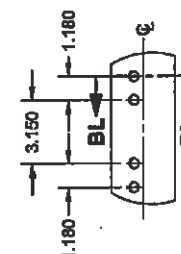
DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL



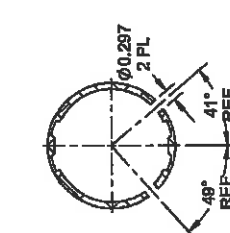
DETAIL BF
SCALE 2X



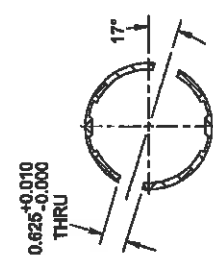
DETAIL BG
SCALE 2X



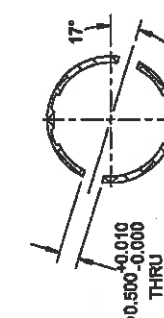
DETAIL BH
SCALE 2X



SECTION B-L-BJ
SCALE 4X, 17 PL



SECTION BK-BK
SCALE 4X, 4 PL



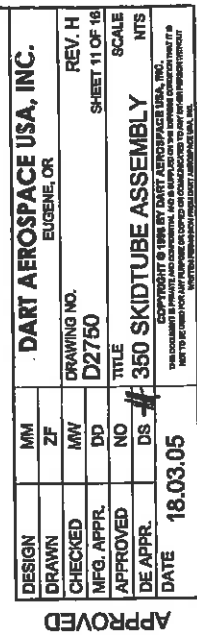
SECTION BL-BL
SCALE 4X, 4 PL

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MFG. APPR.	DD	REV. H
APPROVED	NO	SHEET 9 OF 10
DE APPR.	DS	TITLE
DATE	18.03.05	350 SKIDTUBE ASSEMBLY
		SCALE
		NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS										
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date :	Sequence #:	QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY											
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____			Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		
				Completed By				Lead hand / Supervisor				QC / QA Coordinator			